



Dart Aerospace Ltd.  
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**RBE350A93-3303-02**  
**Job Sheet 179426**



Part No: RBE350A93-3303-02

Job Qty: 5 ea

Part Name: Tail Rotor Head Body Extractor Tool



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 8/6/18

Created By: Logan David

Type: SOLD

Description:

Note: RBE350A93-3303-02 REV 4 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 5 Ea  | 8/6/18     | 8/6/18   | 0.00      | 0.00    | Start Up Small Fab-4  |           | MLC      |
| 100   | Small Fab          | 5 pcs | 8/6/18     | 8/6/18   | 0.08      | 5.00    | Small Fab-9           |           | MLC      |
| 110   | QC                 | 5 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | MLC      |
| 130   | Packaging          | 5 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | Packaging3-2          |           | MLC      |
| 140   | QC21-FG            | 5 Ea  | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC21                  |           | MLC      |

Part Op 100 - Assemble as per DWG. Sheet 1 -Loctite 262 B  
Descriptions: 130 - Identify and Stock

Exp: 4/20

DATE  
21  
9-89

SEP 14 2018

## Job BOM

| Part / Item                  | Component Name | Quantity     | Operation             | Container |
|------------------------------|----------------|--------------|-----------------------|-----------|
| 91030A031 6A067              | Flange Hex Nut | 10 Ea (2 ea) | 90-Start up Operation | 5050896   |
| RBE350A93-3303-02-1 water    | Receiver       | 5 Ea (1 ea)  | 90-Start up Operation | 5096006   |
| RBE350A93-3303-02-3 water    | Extractor      | 5 Ea (1 ea)  | 90-Start up Operation | 5096424   |
| RBE350A93-3303-02-5 141A-100 | Extractor Pin  | 5 Ea (1 ea)  | 90-Start up Operation | 5079438   |
| RBE350A93-3303-02-7 141A     | Stud           | 10 Ea (2 ea) | 90-Start up Operation | 5102649   |

5076784

## Job Allocations

| Operation             | Component Part      | Required | Inventory | Allocated |
|-----------------------|---------------------|----------|-----------|-----------|
| 90-Start up Operation | 91030A031           | 10       | 27        | 0         |
|                       | RBE350A93-3303-02-1 | 5        | 10        | 0         |
|                       | RBE350A93-3303-02-3 | 5        | 10        | 0         |
|                       | RBE350A93-3303-02-5 | 5        | 85        | 0         |
|                       | RBE350A93-3303-02-7 | 10       | 8         | 0         |

## Part Specifications

Specifications could not be found.

Plex 6/19/18 8:39 AM dart.logan.david



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**Container No: S110262**



**Part: RBE350A93-3303-02**

**Job No: 179426**

**Serial No/Batch: S110262**

**Revision: 4**

**Inspector:**

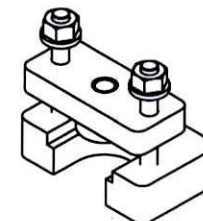
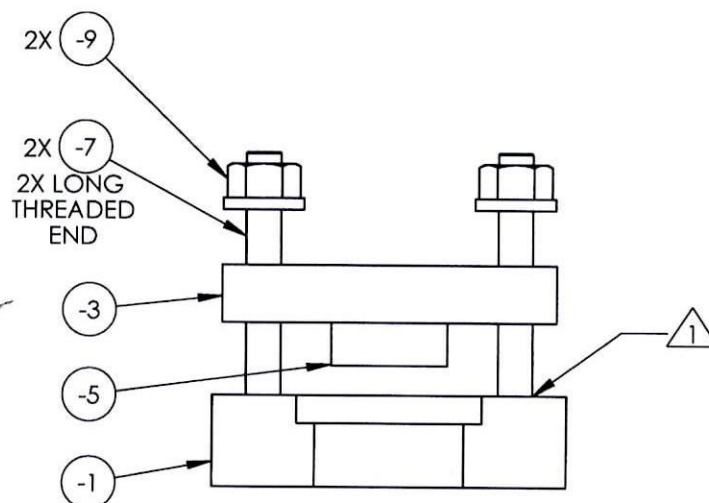
**Exp Date:**

**Instructions:**

**Date: 09/14/18**

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| REVISIONS |         |                                                                                                                                                                                   |           |         |          |
|-----------|---------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                                                                                                                                       | DATE      | INITIAL | APPROVED |
| 1         |         | CH'D FROM HEX BOLTS & SET SCREWS TO STUDS. -1 ADDED R.25 TO CORNERS. -3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.                                                          | 12/4/2008 | WP      | DW       |
| 2         |         | -11 ADDED LOCTITE TO BOM. -5 ADDED .03 X 45° CHAMFER.                                                                                                                             | 12/4/2008 | WP      | DW       |
| 2A        |         | CORRECTED T/N AND TOOL NAME WAS RBEA93-3303-02, T/R HUB BODY EXTRACTOR TOOL IS RBE350A93-3303-02, T/R BODY EXTRACTOR TOOL.                                                        | 11/5/2013 | RJC     | RW       |
| 3         |         | -3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625). -5 CH'D DIM WAS Ø.501 IS Ø.5010 - .5015. -9 CH'D WAS SWIVEL HEX NUT #90477A031 IS FLANGE HEX NUT #91030A031. | 3/13/2014 | DPD     | GE       |
| 4         | 15-0132 | -1 & -3 CH'D MATERIAL WAS 1018 IS A36/1018/1020. -5 CH'D MATERIAL WAS 4140 G&P IS 4140/4142 Q&T.                                                                                  | 6/10/2015 | RJC     | JAG      |



NOTE:

1 2X LOCTITE ON THREADS -7 TO -1.

| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description    | Material      | B/O INFORMATION OR SPECIFICATIONS                     | PG. |
|----------|----------|-----|--------|----------|----------------|---------------|-------------------------------------------------------|-----|
|          |          |     | -1     | 1        | RECEIVER       | A36/1018/1020 |                                                       | 2   |
|          |          |     | -3     | 1        | EXTRACTOR      | A36/1018/1020 |                                                       | 3   |
|          |          |     | -5     | 1        | EXTRACTOR PIN  | 4140/4142 Q&T |                                                       | 4   |
|          |          |     | -7     | 2        | STUD           | STEEL         | 3/8-16 UNC-2A X 4 (MCMASTER-CARR #90281A640) MODIFIED | 5   |
|          |          | B/O | -9     | 2        | FLANGE HEX NUT | STEEL         | 3/8-16 UNC-2B (MCMASTER-CARR #91030A031)              | 1   |
|          |          | B/O | -11    | AR       | 262 LOCTITE    |               | (MCMASTER-CARR #91458A180)                            | N/S |

|                                                                                                                                    |                                                                                     |
|------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>                                                                                                          |                                                                                     |
| TITLE<br><b>T/R BODY EXTRACTOR TOOL</b>                                                                                            |                                                                                     |
| DWG NO.<br><b>RBE350A93-3303-02</b>                                                                                                | REV<br><b>4</b>                                                                     |
| MAT'L<br>UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/8<br>.XX ± .01 ANGLES ± 5°<br>.X ± .1 | DRAWN BY: <b>PERRITT</b><br>APPROVED: <i>D Weir</i><br>HEAT TREAT<br>FINISH<br>SPEC |
| 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R                                                                                       |                                                                                     |
| 2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                                                                          |                                                                                     |
| SCALE<br><b>1:2</b>                                                                                                                | DATE<br><b>10/27/2008</b>                                                           |
| USED ON MODEL<br><b>EUROCOPTER AS350A</b>                                                                                          |                                                                                     |
| SHEET 1 OF 5                                                                                                                       |                                                                                     |